

Work Order ID 123974

123974

Page 1

September-04-14 11:56:00 AM

Item ID: D6009-129 *Split 9* Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Material
 Start Date: 9/04/14 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 12/15/15 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-09-04 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D6009	Rev A								

100 0.00

100

PURCHASING

Purchasing
Purchasing

Memo

Issue P/O: 25798

0.00

- a) Order as per Dwg D6009
- b) Material: 3.500 x 0.625 wall 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) seamless aluminum tube
- c) Minimum ultimate tensile strength = 77 ksi
- d) Minimum tensile yield strength = 66 ksi
- e) Tolerance are per ASTM B210 (see details on Dwg D6009)
- f) Material certification required

EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

CX 14/09/16 20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 123974

123974

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September-04-14 11:56:00 AM

Item ID: D6009-129 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Crosstube Material
 Start Date: 9/04/14 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 12/15/15 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D6009								
140	Identify as per dwg & Stock Location: <u>L6003</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									

9
 OCT 23 2014
 DAS
 6
 9-89

(9)
 NOV 02 2015
 DAS
 38
 9-89

(9)
 15/11/02
 mmL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 123974

123974

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September-04-14 11:56:00 AM

Item ID: D6009-129

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Material

Start Date: 9/04/14 Start Qty: 20.00

20

Cust Item ID:

Required Date: 12/15/15 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

ML5 NOV 0 2 2015

ML5 NOV 0 3 2015

DQA: _____ Date: _____



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Picklist Print

September-04-14 11:56:03 AM

Page 1

Work Order ID: 123974

123974

Parent Item: D6009-129

D6009-129

Parent Item Name: Crosstube Material

Start Date: 9/04/14

Required Date: 12/15/15

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A01.08.17New IssueSM
alodine DD 10.01.09 verified by:JLM

IPP Rev:B remove

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6009-129P		Purchased	No			110	Each	20.0000	1	20			
D6009-129P									**				
Crosstube Material													

Location

Loc Qty

Loc Code

HALL

20

107865

20

DAS
6
3-09

NOV 03 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

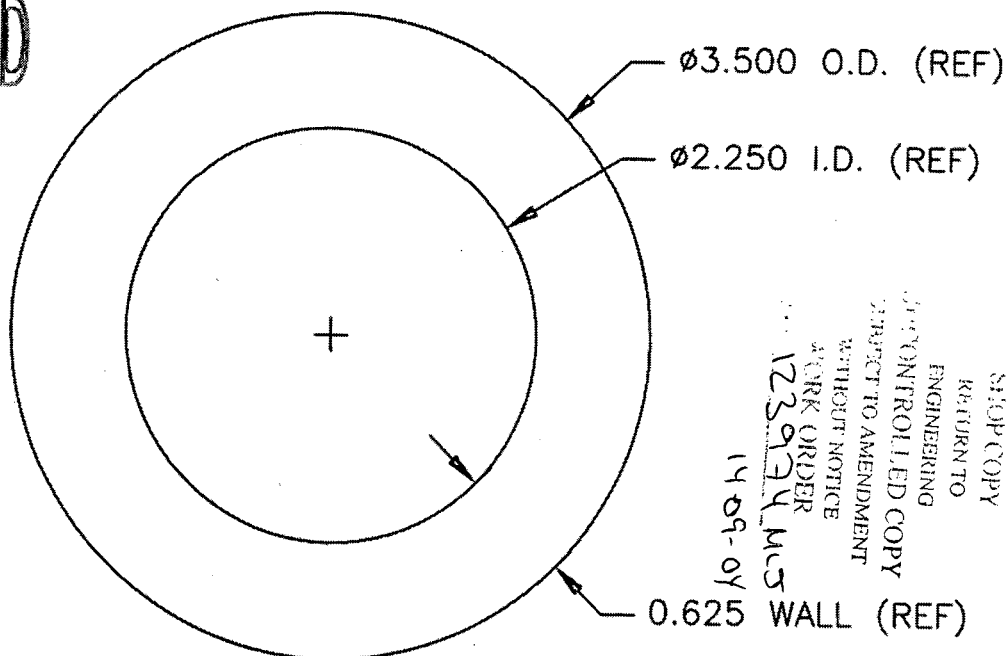
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D6009	REV. A SHEET 1 OF 1
DATE 01.08.16		TITLE CROSSTUBE MATERIAL	SCALE 1:1
A	01.08.16	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.08.17 #



NOTES

- 1) D6009-XXX CROSSTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 129" LONG TUBE: D6009-129

- 2) MATERIAL: 3.500 OD x 0.625 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.008 MEAN (± 0.016 INCLUDING OVALITY)
WALL: ± 0.020 MEAN (± 0.063 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.188/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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Packinglist ALUnna AG

ALUnna ref. no.	54642/1200
Customer PO.	PO. 25798
Date:	09.29.15

Boxmarking:

Dart Aerospace PO. 25798
D 6009-129 Made in Germany
Dest. Hawkesbury Ont., Canada

We hereby declare that the wooden packing material are totally free from bark and apparently

free from live plant pests

[illegible]



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25798

Purchase Order Date 9/16/2014

PO Print Date 9/23/2014

Page Number 4 of 5

Order From :

VU-ALU001

Ship To : DART AEROSPACE LTD

ALUMINIUMWERK UNNA AG
630 3033 SOUTH PARKER RD
AURORA, CO 80014
USA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 303 755 5672

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Ship To Phone

Ship Via:

Contract Shipping

Ship Acct:

Terms

Wire

Currency

USD

FOB

DDP - (Delivered Duty Paid)

10 D6005-128P

Crosstube Material

12/15/2015

Yes

12/15/2015

EXTRUDE AS PER DWG D6005-128 REV. B
B123965

Rec'd 16/15/10/23

Line Total:

\$17,545.00

28.00
Each

\$523.00

\$14,644.00

11 D6006-129P

Crosstube Material

12/15/2015

Yes

12/15/2015

EXTRUDE AS PER DWG D6006-129 REV. A
B123969

Rec'd 21/15/10/23

Line Total:

\$14,644.00

20.00
Each

\$1,002.00

\$20,040.00

12 D6009-129P

Crosstube Material

12/15/2015

Yes

12/15/2015

EXTRUDE AS PER DWG D6009-129 REV. A
B123974

Rec'd 9/15/10/23

Line Total:

\$20,040.00

20.00
Each

\$1,254.00

\$25,080.00

Note:

9/23/2014

SP/5-10-22

delivery note

90252

page: 2
date: 30.09.2015
customer: 40980

Packing: seaworthy wooden cases
number of packages: 1
number of pieces: 16

item	quantity	unit	net kgs
1100	21,000	PC	

AWU article: 35311 / Tariff no. 76082081
Customer article: D6006-129 3.250 X 0.515 X 129 / cust. drwg.
product: Tubes / seamless extruded / EN AW-7075 / round
condition: T 6511 / AMS-QQ-A-200/11(A)
outer diameter: 3,250 INCH Tol. +0,016 -0,016
inner diameter: 2,220 INCH
wall thickness: 0,515 INCH Tol. +0,052 -0,052
fixed length 129,000 INCH Tol. +0,188
test report acc. to EN 10204/3.1 / RM 531 / Rp0,2: 455
straightness 0,01 INCH / 1 FEET / RMS max.: outer 25
tol. on quantity +10 % -10 % / scurfed
3.250" OD 0.515" Wall, 129" lengths
Part Number D6006-129 crosstube
Surface Finish max. RMS 25
Tolerances per ASTM B210 / drawing D6006
Tubes protected with corrosion protective oil
Tubes line marked

Packing: seaworthy wooden cases
number of packages: 1
number of pieces: 21

item	quantity	unit	net kgs
1200	9,000	PC	

AWU article: 37272 / Tariff no. 76082081
Customer article: D6009-129 3.500 X 0.625 X 129 / cust. drwg.
product: Tubes / seamless extruded / EN AW-7075 / round
condition: T 6511 / AMS-QQ-A-200/11(A)
outer diameter: 3,500 INCH Tol. +0,016 -0,016
tol. for mean OD +0,008 -0,008
inner diameter: 2,250 INCH
wall thickness: 0,625 INCH Tol. +0,063 -0,063
fixed length 129,000 INCH Tol. +0,188
test report acc. to EN 10204/3.1 / RM 531 / Rp0,2: 455
straightness 0,01 INCH / 1 FEET / RMS max.: outer 25
tol. on quantity +10 % -10 % / scurfed
3.500" OD 0.625" Wall, 129" lengths
Part Number D6009-129 crosstube
Surface Finish max. RMS 25
Tolerances per ASTM B210
Tubes protected with corrosion protective oil

delivery note**90252**

page: 3
date: 30.09.2015
customer 40980

number of pieces:

9

Terms of payment: 30 days after date of delivery
terms of delivery: DDP(Delivered,Duty,Paid)

weight: gross 1424,500 net 1120,000

Packstücke 3

customer address:

DART AEROSPACE LTD.
1270 Aberdeen Street
HAWKESBURY ON K6A 1K7
Kanada

EXTRUSION INSPECTION SHEET



		SIDE A		SIDE B		Measurement unit Inches		Symbol "		ULTRA SONIC MEASUREMENTS					
TUBE #	TOTAL LENGTH	DIA		DIA		INSIDE DIA	wall thickness measured w/vern		Strightness at 12" in middle	Rockwell Reading	LOCATION on tube	R1	R2	R3	R4
DWG		R1	R2	R1	R2										
										N/A	Middle	N/A			
1	129"	3.49	3.50	3.505	3.491	2.253	.630	.623	.00015	N/A	Middle	.622	.631	.631	.624
2	129"	3.493	3.532	3.517	3.495	2.252	.634	.613	.01310	N/A	Middle	.628	.645	.624	.612
3										N/A	Middle				
4										N/A	Middle				
5										N/A	Middle				
6										N/A	Middle				
7										N/A	Middle				
8										N/A	Middle				
9										N/A	Middle				
10										N/A	Middle				
11										N/A	Middle				
12										N/A	Middle				
13										N/A	Middle				
14										N/A	Middle				
15										N/A	Middle				
16										N/A	Middle				
PART #		D6009-129				P/O#		25798		BATCH #		123974		Notes:	